



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2052

Job Sheet 168308



Part No: D2052

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/20/17

Created By: Linda Lacelle

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/18/17	0.00	0.00	Start Up Waterjet		DL 17/12/28
100	Waterjet	10 pcs		11/18/17	0.00	0.46	Waterjet1		DL 17/12/28
110	QC	10 pcs		11/18/17	0.00	0.00	QC2		DL 17/12/28
120	QC	10 pcs		11/18/17	0.00	0.00	QC8		38
130	Brake NC	10 pcs		11/18/17	0.01	0.24	Brake NC 1		9-89 SB
140	QC	10 pcs		11/18/17	0.00	0.00	QC5		215
150	HandFinish	10 pcs		11/18/17	0.00	0.20	HandFinish1		18-02-06 JSL
160	Powdercoat	10 pcs		11/20/17	0.00	0.08	Powdercoat4		BR 18-02-06
170	QC	10 pcs		11/20/17	0.00	0.00	QC3		38
180	Packaging	10 pcs		11/20/17	0.00	0.00	Packaging3	GA	9-89
190	QC21-SA	10 Ea		11/20/17	0.00	0.00	QC21		52

Part Op 100 - 1-Cut as per Dwg D2052 Prog Rev: D ****grain direction along 3.878" ****

Descriptions: 130 - Form as per Dwg D2052 using CNC Brake

160 - START TIME: 9:00 OVEN TEMPERATURE: 320° FINISH TIME: 9:50

180 - LOCATION : GA

D2052
21
9-89

FEB 09 2018

11/38700

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M5052H32S.090	1	51	0	0

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:52 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION S027179 Bracket	DART AEROSPACE	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		QTY Effective : _____ Disposition _____ _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval														
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

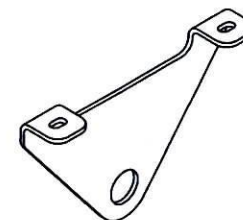
Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Misidentified ☐	Past Due ☐								

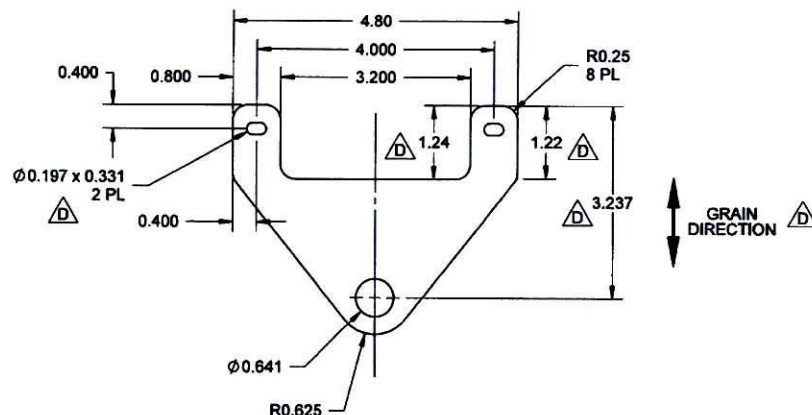
NOV 16 2017

DAS
30
9-89

NO. 168328
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



D2052 BRACKET



D2052F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

RELEASED
08-05-13/14

D	WIDEN SLOT (ZN 87-1); UPDATE FLAT PATTERN DIMENSIONS (ZN 85-1, 86-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANTEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A8-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)		PH	08.04.28
C	ADD FLAT PATTERN		RF	99.04.30
B	ADD SLOT TO FOOT		BW	97.02.21
A	NEW ISSUE		BW	92.01.12
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2052 TITLE BRACKET REV. _____ SHEET 1 OF 1 SCALE _____ NTS _____		
DRAWN	<i>PL</i>			
CHECKED	<i>JP</i>			
MFG. APPR.	<i>MP</i>			
APPROVED	<i>MP</i>			
DE APPR.	<i>MP</i>	COPYRIGHT © 1982 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	08.04.28			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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